

# Work Order ID 69428

Wednesday, May 11, 2011 9:48:29 AM

12/05



Page 1

Item ID: D3026-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Channel

Start Date: 5/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3026	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3026

Dwg Rev: *8*

Prog Rev: *8*

2-Deburr if necessary

81-5-17

⑦

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

81-5-17

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Start Date: 5/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/11/05/17

(47)

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

Deburr if necessary

Form as per Dwg D3026

0.00

SB 11/05/17

(7)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/05/18

(47)

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Item ID: D3026-1

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Setup Start



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Stop



Item Name: Channel

Start Date: 5/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							76 BL 11518
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							11/5/11 SP 7D
170  Packaging Packaging	Identify as per dwg & Stock Location: 177  Memo	0.00  0.00							11/5/11 SP 7D

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Start Date: 5/11/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/5/18

11-05-18  
②

# Picklist Print

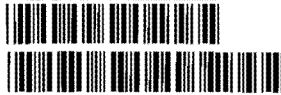
Wednesday, May 11, 2011 9:48:26 AM

Page 1

Work Order ID: 69428

Parent Item: D3026-1

Parent Item Name: Channel



Start Date: 5/11/2011

Required Date: 5/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP D1105.10.07 Added forming step and Issue P/O KJ/JLM  
IPP E 07.01.04 waterjet ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

0.0000

0.495

3.126316



B11-5-17

2024-T3 .050 sheet

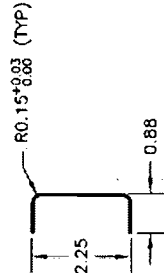
117684

⑦

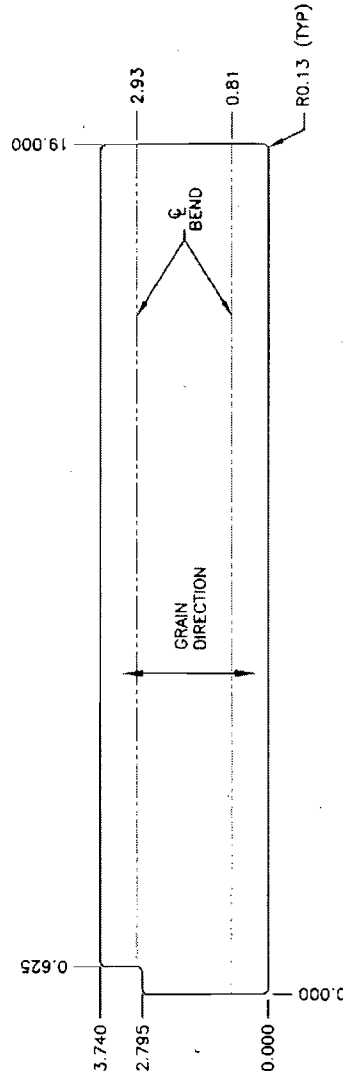
69428



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3026	REV. B SHEET 1 OF 1
DATE	05.09.20			TITLE CHANNEL	SCALE 1:4
A	01.05.18			NEW ISSUE	
B	05.09.20			REMOVE HOLES	



D3026-1 BEND DETAIL



D3026-1 FLAT PATTERN

*db 19428*

- NOTES:
- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
  - 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050" THICK
  - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
25.10.23 *[Signature]*

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